

CLAIMS

What is claimed is:

1. A profiled frame for a motor vehicle door, manufactured as a roll-formed profile from metal flat strip material, comprising a hollow profile and an additional profile which is separate from the hollow profile, said additional profile being permanently and rigidly connected with said hollow profile and comprising at
5 least one contact surface or one attachment formation.
2. The profiled frame according to claim 1, characterized by the fact that the flat strip material is flat steel.
3. The profiled frame according to claim 1, characterized by the fact that the hollow profile is closed off.
- 5 4. The profiled frame according to claim 1, characterized by the fact that a flange is provided at the hollow profile, following the progression of the hollow profile .
5. The profiled frame according to claim 4, characterized by the fact that the hollow profile and/or the flange also feature a contact surface and/or an attachment
10 formation.
6. The profiled frame according to claim 1, characterized by the fact that the additional profile is welded or soldered to the hollow profile .
7. The profiled frame according to claim 1, characterized by the fact that the additional profile is manufactured as a roll formed profile from flat strip material.
- 15 8. The profiled frame according to claim 7, characterized by the fact that the additional profile is made of flat steel.
9. The profiled frame according to claim 1, characterized by the fact that the hollow profile features an essentially unchanging cross-section.
10. The profiled frame according to claim 3, characterized by the fact
20 that the hollow profile features an essentially unchanging cross-section.
11. The profiled frame according to claim 10, characterized by the fact that the additional profile is welded or soldered to the hollow profile .

25 12. The profiled frame according to claim 1, characterized by the fact that the length of the hollow profile and the length of the additional profile differ from each other.

13. The profiled frame according to claim 1, characterized by the fact that the length of the hollow profile and the length of the flange differ from each other.

30 14. The profiled frame according to claim 1, characterized by the fact that the length of the additional profile and the length of the flange differ from each other.

15. The profiled frame according to claim 13, characterized by the fact that the length of the additional profile and the length of the flange differ from each other.

35 16. The profiled frame according to claim 15, characterized by the fact that the length of the hollow profile and the length of the additional profile differ from each other.

17. The profiled frame according to claim 1, characterized by the fact that the profiled frame is a door window frame of a motor vehicle door or lid.

40 18. The profiled frame according to claim 17, characterized by the fact that the hollow profile features a considerable excess at at least one end for anchoring the profiled frame below the parapet line in a door box of the motor vehicle door or lid.

19. The profiled frame according to claim 18, characterized by the fact that the hollow profile features an excess of 20 mm to 120 mm at at least one end.

45 20. The profiled frame according to claim 19, characterized by the fact that the hollow profile features an excess of 30 mm to 80 mm at at least one end.

21. The profiled frame according to claim 1, characterized by the fact that the hollow profile is closed off by welding or by soldering.

50 22. The profiled frame according to claim 21, characterized by the fact that the weld seam of the hollow profile is located within the outer contour of the hollow profile.

23. The profiled frame according to claim 22, characterized by the fact that the additional profile is welded or soldered to the hollow profile.

24. The profiled frame according to claim 1, characterized by the fact that the profiled frame is straight and not cambered to the outside, and that a design-
55 dependent camber or similar feature is achieved by additional mounted parts.

25. The profiled frame according to claim 1, characterized by the fact that the additional profile, at its end assigned to the B-pillar, is shortened compared to the hollow profile.

26. The profiled frame according to claim 25, characterized by the fact
60 that the additional profile, at its end assigned to the B-pillar, is shortened compared to the hollow profile by 20 mm to 60 mm.

27. The profiled frame according to claim 26, characterized by the fact that the additional profile, at its end assigned to the B-pillar, is shortened compared to the hollow profile by 30 mm to 50 mm.

65 28. The profiled frame according to claim 1, characterized by the fact that the profiled frame is formed by permanently and rigidly connecting the hollow profile, the additional profile(s) and, where applicable, the flange in their straight condition, and then stretch-bending together.

29. The profiled frame according to claim 1 wherein the profiled frame is
70 a door window frame and is part of a motor vehicle door or lid having an outer door wall, an inner door wall and an interior lining.

30. The profiled frame according to claim 29, characterized by the fact that the hollow profile of the profiled frame features a considerable excess at at least one end for anchoring the profiled frame below the parapet line in a door box (7) of the
75 motor vehicle door or lid, and that the profiled frame is anchored to this excess in the door box of the motor vehicle door or lid.

31. The profiled frame according to claim 30, characterized by the fact that the anchoring of the profiled frame is accomplished by welding, soldering, screwing or riveting.

32. A method for manufacturing a profiled frame as a window frame and/or door frame of a motor vehicle door or lid,

where the profiled frame features a hollow profile and at least one contact surface and/or attachment formation on the hollow profile,

5 in which in a first procedure step the hollow profile is manufactured from flat strip material by roll forming,

in which in a third procedure step an additional profile is manufactured featuring at least one contact surface and/or attachment formation,

10 in which in a fourth procedure step the additional profile is permanently and rigidly connected with the hollow profile .

33. The manufacturing method according to claim 32, characterized by the fact that in a second procedure step the hollow profile is closed off to a closed hollow profile by means of linear welding along a weld seam.

34. The manufacturing method according to claim 32, characterized by the fact that in the fourth procedure step the additional profile is welded or soldered to the hollow profile .

35. The manufacturing method according to claim 32, characterized by the fact that the fourth procedure step is temporally independent from the first procedure step.

36. The manufacturing method according to claim 32, characterized by the fact that the additional profile is manufactured from flat strip material by roll forming.

37. The manufacturing method according to claim 32, characterized by the fact that in the first procedure step a flange is fashioned together with the hollow profile as one piece, said flange following the progression of said hollow profile.

38. The manufacturing method according to claim 32, characterized by the fact that in the initial procedure steps the profiled frame is formed by permanently and rigidly connecting the hollow profile, the additional profile(s) and, where applicable, the flange in their straight condition, and that only subsequently in a fifth
5 procedure step the profiled frame is stretch-bent to its final form.

39. The manufacturing method according to claim 38, characterized by the fact that in a sixth procedure step occurring after the first procedure step and before the fifth procedure step, the flange is cut the a desired length at the hollow profile.